



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D5853-041

Job Sheet 207577

POSITIVE  
RECALL

Part No: D5853-041

Job Qty: 6 pcs

Part Name: Basket Rim Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/20

Job Tracking No:

Due Date: 4/27/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG D5853 Rev A IPP Rev. A 2020.01.30 New issue DP Verify DD

Ship Via:

## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	6 pcs	4/27/20		0.00	1.20	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
160	QC 5	6 pcs	4/27/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S264226



Part: D5853-041

Job No: 207577

Serial No/Batch: S264226

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: T 613 632-5200  
Email: sales@dartaero.com  
www.dartaero.com

Date: 03/17/20

DAS  
MAR 17 2020 40  
9-89

170 Packaging 3-1 - Stock - B4B 6 pcs

4/27/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

MAC

180 QC 21 - SA

6 pcs

4/27/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

MAR 18 2020

Part Op 100 - 1- Cut as per dwg D5853-1 2-Drill holes with DT10653 as per dwg D5853-1 \*\*\*DRILL ONE SIDE\*\*\* 3-Deburr.  
 Descriptions: \*\*\*Note that the welding and back drilling of support D5853-7 will be done on top level weldment to accommodate welding fixture.\*\*\*

160 - QC5- Inspect part completeness to step on W/O \*\*\*Welding will be done on top level weldment\*\*\*

170 - Identify as per dwg & Stock Location: W/O As per drawing, see note 6.

180 - QC21- Final Inspection - Work Order Release

## Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NTS0.750W.035	4130 Square Tube 0.750 X 0.035W	11.4000 ft (1.9 ea)	100-Large Fab - Basket - 1	5250 794

## Job Allocations

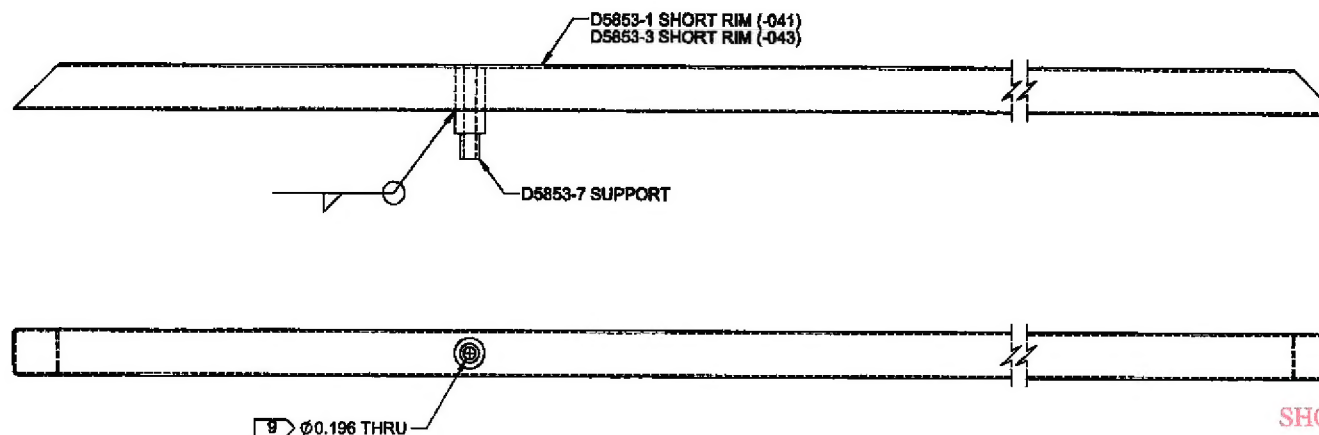
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	M4130NTS0.750W.035	11	324	0

## Part Specifications

Specifications could not be found.



QTY -041	QTY -043	P/N	DESCRIPTION
X		D5853-041	BASKET RIM WELDMENT
	X	D5853-043	BASKET RIM WELDMENT
1		D5853-1	SHORT RIM
	1	D5853-3	SHORT RIM
1	1	D5853-7	SUPPORT



**D5853-041 BASKET RIM WELDMENT**  
**D5853-043 BASKET RIM WELDMENT**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER

UNDER REVIEW  
 URF 2020-522 20.02.14 (NO)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: -041: 0.65 lbs  
-043: 0.73 lbs
  - 8) WELD PER DART QSI 004
  - 9) DRILL THRU SUPPORT AND TUBE AFTER WELDING.

**RELEASED**  
 2020 FEB 18 *ND*  
 ECV 2020-524

APPROVED

A	NEW ISSUE	ZF	20.01.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.24		

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5853

TITLE

BASKET RIM

REV. A

SHEET 1 OF 6

SCALE

NTS

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8

7

6

5

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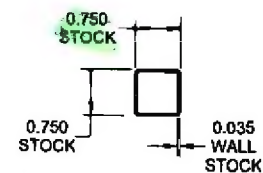
2

1

45°  
2 PL22.50 FOR -1  
25.50 FOR -3

7.56

0.56

Ø0.500 THRU  
ONE SIDE**D5853-1 SHORT RIM**  
**D5853-3 SHORT RIM**

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

## NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL  
PER MIL-T-8736 OR AMS 6371/6360/6361/6362/6373/6374  
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -1: 0.59 lbs  
-3: 0.66 lbs

**RELEASED**2020 FEB 18 *Wd*

APPROVED

DESIGN	ZF
DRAWN	ZF
CHECKED	KPT
MFG. APPR.	DD
APPROVED	NO
DE APPR.	CP
DATE	20.01.24

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**D5853**

TITLE

**BASKET RIM**

REV. A

SHEET 3 OF 6

SCALE

NTS

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Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER POHB045594



**Supplier:** FAC001-VU  
Factory Steel  
14020 Oakland Ave.  
Detroit, MI 48203 USA  
Phone: 313 883 6300  
Fax: 313 883 4883

**PO No:** POHB045594

**PO Date:** 1/16/20

**Due Date:** 2/4/20

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Phone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground

**Pynt Terms:** Net 30

**Freight Terms:**

**Special Comments:**

JAN 16 2020

## Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		M4130NTS0.750W.035			4130 Square Tube 0.750 X 0.035W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed -		2/4/20	600 ft	0 ft	600 ft	\$7.25/ft	\$4,350.00
2		M4130NTS1.000W.065			4130 Square Tube 1.000" X 1.000" X 0.065"W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed -		2/4/20	160 ft	0 ft	160 ft	\$11.70/ft	\$1,872.00

609 ft  
OK  
C. Lavoie

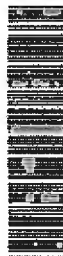

1714 ft  
OK  
C. Lavoie

**Grand Total: \$6,222.00**

# PACKING LIST

No. 67371

PG 1 OF 1

 PL  SO	FACTORY STEEL & METAL SUPPLY 14020 OAKLAND AVENUE DETROIT, MI 48203  (313)883-6300 PHONE (313)883-4883 FAX		CUSTOMER # POHB045594 CUSTOMER JOB		BUYER CHANTEL LAVOIE Tel (613) 632-3336 Fax (613) 632-4443		SHIP DATE 01/21/2020 SHIP VIA *****TRUCK*****	
			SALES ORDER 60306	ORDER DATE 01/16/2020	SALES REP MICK HALON		RESALE # 59-2958719	
	SOLD TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP INST CALL WHEN READY PRO#		CARRIER TRUCK BLIND Y/N N	
					TERMS NET 30 DAYS		FOB DETROIT	

LINE	QUANTITY	DESCRIPTION	WIDTH	LENGTH	WEIGHT
1	609.917 FT	4130N CD SMLSS SQ TUBE 3/4" X .035W  Tag Mill Ref # Heat 153513 023679 616506	Pcs Length 26 20' / 24' RL	20' / 24' RL  Feet 609.917	207.554  Weight 207.554
2	171.333 FT	4130N CD SMLSS SQ TUBE 1" X .065W  Tag Mill Ref # Heat 153514 072143 072067859	Pcs Length 7 22' / 23' RL	22' / 23' RL  Feet 171.333	141.606  Weight 141.606
3	1 PCS	PACKING CHARGES  MTRS (CIRCLE) FAX SHIPMENT INVOICE ALL DATE: _____ INITIAL: _____			

TOTAL WT 349 LBS									
RECEIVED BY - SIGNATURE			RECEIVED BY - PRINTED NAME			DATE RECEIVED			

LIVE!

# MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M4130 NTS 0.750W .035 PO / BATCH NO.: POM13045594  
 DATE: JAN 27 2020 5250794

MATERIAL CERT REC'D: YES  
 QUANTITY RECEIVED: 609 FT  
 QUANTITY INSPECTED: 609 FT  
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .750W .035  
 THICKNESS RECEIVED: .750W .035  
 SHEET SIZE ORDERED: —  
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(X) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(X) N	
CORRECT MATERIAL PER M-DRAWING	(X) N	MIL-T-6736
CORRECT THICKNESS	(X) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(X) N	616506
CORRECT MATERIAL IDENTIFICATION	(X) N	
CORRECT M# ON THE MATERIAL	(X) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (X)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

*testers located in the Quality Office*

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: _____		
DATE: <u>JAN 27 2020</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



LIVE 1  
M4130NTS 0.750W.035

S250794

616506



DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. M4130N-TS	REV. A SHEET 1 OF 1
DATE 05.02.09		TITLE 4130N SQUARE TUBING	SCALE NTS
A	05.02.09	NEW ISSUE	

PURCHASE MATERIAL:

AISI4130N STEEL SQUARE TUBING PER ONE OF  
THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371,  
6360, 6361, 6362, 6373 OR 6374

DAS  
82  
9-85

PART NUMBER: M4130N-TS | A.AAA | W | .TTT |

WHERE A.AAA = WIDTH IN INCHES  
TTT = WALL THICKNESS IN INCHES

EXAMPLE: 0.50" X 0.035" WALL = M4130N-TS0.500W.035

RELEASED  
05.02.09

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**PLYMOUTH TUBE CO.**

1280 East 12th Street, Streator, Illinois 61354

Phone: (815) 675-1616 Fax: (815) 672-7363

TRUST YOUR SOURCE! ACCEPT NO SUBSTITUTION!



## PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / C

### SHIP TO

Factory Steel & Metal Supply C  
14020 Oakland Avenue  
Detroit, MI 48203  
USA

WORK ORDER 023679

PCS/HEAT 0

HEAT NUMBER 616508

MELT SOURCE Benteler Steel & Tube-Germany

CUSTOMER P.O. 3887	CUSTOMER PART SQ-N34035	QUANTITY	LADING NO	CERT ID / REV /	CERT DATE								
<b>PART DESCRIPTION</b> SHSQ0750035J300 ***** Square OD ***** Side1: 0.7500 Max:0.7600 Min:0.7400 Side2: 0.7500 Max:0.7600 Min:0.7400 Wall: 0.0350 Max:0.0380 Min:0.0320 Length: 19.00/28.00 Spec: MIL-T 6736B Seamless Aircraft Grade: 4130 Anneal: Cond N													
<b>CERTIFICATION REQUIREMENTS</b> FAR BAA (FAR 52.225-1 Buy America Act Supplies), DFARS 252.225-7001 By America Act & Bal. of Payments Program FAR TAA (FAR 52.225-5 Trade Agreements)(Paragraph 1,3,4,5)This material was Edge Current tested and conforms to the requirements of ASTM A-450. The Grain size is determined and reported by the raw material supplier in accordance to ASTM E-112. This raw material was magnetic particle inspected by the raw material supplier in accordance to AMS 2640J and/or ASTM E-1444, and rated as Frequency, and Severity to AMS 2301, latest revision. Yield is determined by using the 0.2% offset method. Additional Specifications - AMS-T 6736B, 6360P & 6371L. Material produced in accordance to ASTM A-519-17 and MIL-T 6736B. This material meets Plymouth ProMoly specifications. Jominy results: J(5/16")=45 J(8/16")=38													
<b>Chemical Analysis</b>													
C	Mn	P	S	Si	Al	Cr	Mo	Ni	Pb	Cu	V	Ti	Sn
.310	.55	.011	.002	.230	.036	.87	.18	.12	.001	.16	.002	.002	.010
<b>Physical Properties</b>													
Freq.	Severity	Grain Size											
.020	.015	9											
<b>Mechanical Properties</b>													
<b>TEST</b>	<b>UNITS</b>	<b>TESTS</b>	<b>HIGH</b>	<b>LOW</b>	<b>AVERAGE</b>	<b>STD-DEV</b>							
Tensile	Psi	6	126660	125480	126065	482							
Yield	Psi	6	120830	119880	120367	374							
Elongation	%	6	21	20	20	1							
Rockwell C	Rc	6	25	25	25	0							
<b>TEST</b>	<b>RESULT</b>												
Decarb/OD	Pass												
Total ID/OD decarb	Pass												

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streator in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

*James Crosswell*  
Quality Assurance

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**PLYMOUTH TUBE CO.**

1200 East 12th Street, Detroit, Michigan 48203  
Phone: (313) 678-1616 Fax: (313) 678-7343

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# PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / 0

## SHIP TO

Factory Steel & Metal Supply C  
14020 Oakland Avenue  
Detroit, MI 48203  
USA

WORK ORDER 023678

PCS/HEAT 0

HEAT NUMBER 616506

MELT SOURCE Bunnell Steel & Tube-Germany

CUSTOMER P.O. 3887	CUSTOMER PART SQ-N34035	QUANTITY	LADING NO	CERT ID / REV /	CERT DATE
PART DESCRIPTION SHSQ0750035J300					
Additional Specification(s)					
<u>TEST</u> Brinell	<u>UNITS</u> Brinell	<u>#TESTS</u> 6	<u>HIGH</u> 253	<u>LOW</u> 253	<u>AVERAGE</u> 253
<u>STD-DEV</u> 0					
<p>This test report data is for the heat Chemistry Stated above.</p> <p>The material in this test report is:</p> <ol style="list-style-type: none"> <li>1) Drawn in the USA</li> <li>2) Free from Polybrominated Biphenyls (PBB), Polybrominated Diphenyl Ethers (PBDE), and Mercury contamination.</li> <li>3) NAFTA compliant.</li> </ol> <p>End of Certification</p>					

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Stratacor in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

*Janine Demoss*  
Quality Assurance

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
<b>Root Cause</b>  Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Preservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		<b>FAULT CATEGORY</b>  <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Follo/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>			
Other/Details:					